

Work Order ID 50498



Page 1

July 10, 2009 2:48:12 PM

Item ID: D3962-1KIV

Accept



Setup Start



Revision ID: A-PROTO

Stop



Item Name: Rear Overhead Corner, LH

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-07-10 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3962

A-PROTO 09.06.18

100

0.00



Hand Thermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA061 using tool DT9341
Dwg Rev:
Folio Rev:

BB 09/07/13 XI

BB 09/07/13 XI

Work Order ID 50498

July 10, 2009 2:48:12 PM

Page 2

Item ID: D3962-1KIV

Accept

Revision ID: A-PROTO

Item Name: Rear Overhead Corner, LH

Start Date: 07/13/2009 Start Qty: 1.00

Required Date: 07/17/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120 QC2- Inspect parts off machine FAI/FAIB

0.00

QC
Quality Control

Memo

Visually inspect part for proper formation and texture

0.00

BB - 09/07/16 (X)

130 QC8- Inspect parts - second check

0.00

QC
Quality Control

Memo

0.00

DL 09/07/14 (X)

140

0.00

Hand Thermo
Hand Finishing Thermoforming

Memo

1-Trim to finished dimensions as per Dwg

0.00

DL 09/07/14 (X)

Work Order ID 50498

July 10, 2009 2:48:12 PM

Page 3

Item ID: D3962-1KIV

Accept

Setup Start

Revision ID: A-PROTO

Stop

Item Name: Rear Overhead Corner, LH

Start Date: 07/13/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150 QC2- Inspect parts off machine FAI/FAIB 0.00

QC

Quality Control Memo Complete FAI document 0.00

160 QC5- Inspect part completeness to step on W/O 0.00

QC

Quality Control Memo 0.00

170 Identify as per dwg & Stock Location: _____ 0.00

Packaging

Packaging Memo 0.00

DL 09/07/14 (1)

DL 07-07-09

RU 09.07.20

ENGINEERING
APPROVAL

FOR
ENG'G
TEST

RU 09.07.20

Work Order ID 50498



Page 4

July 10, 2009 2:48:12 PM

Item ID: D3962-1KIV

Accept



Setup Start



Revision ID: A-PROTO

Stop



Item Name: Rear Overhead Corner, LH

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

BB

09/07/16 (X1) see pg. 1
H-09.07.20 Prototype

Picklist Print

July 10, 2009 2:48:12 PM

Page 1

Work Order ID: 50498



Parent Item: D3962-1KIVRevA-PROTO



Parent Item Name: Rear Overhead Corner, LH

Start Date: 07/13/2009

Required Date: 07/17/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			110	sf	894.5038	1.0000			



6185 KYDEX .080"



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

894.5037653

109703

894.503765

M109703

BB 09/07/13

DART AEROSPACE LTD	Work Order:	50498
Description:	Part Number:	D3962-1 K10
Inspection Dwg: D3962-1 Rev: A PROTOTYPE		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

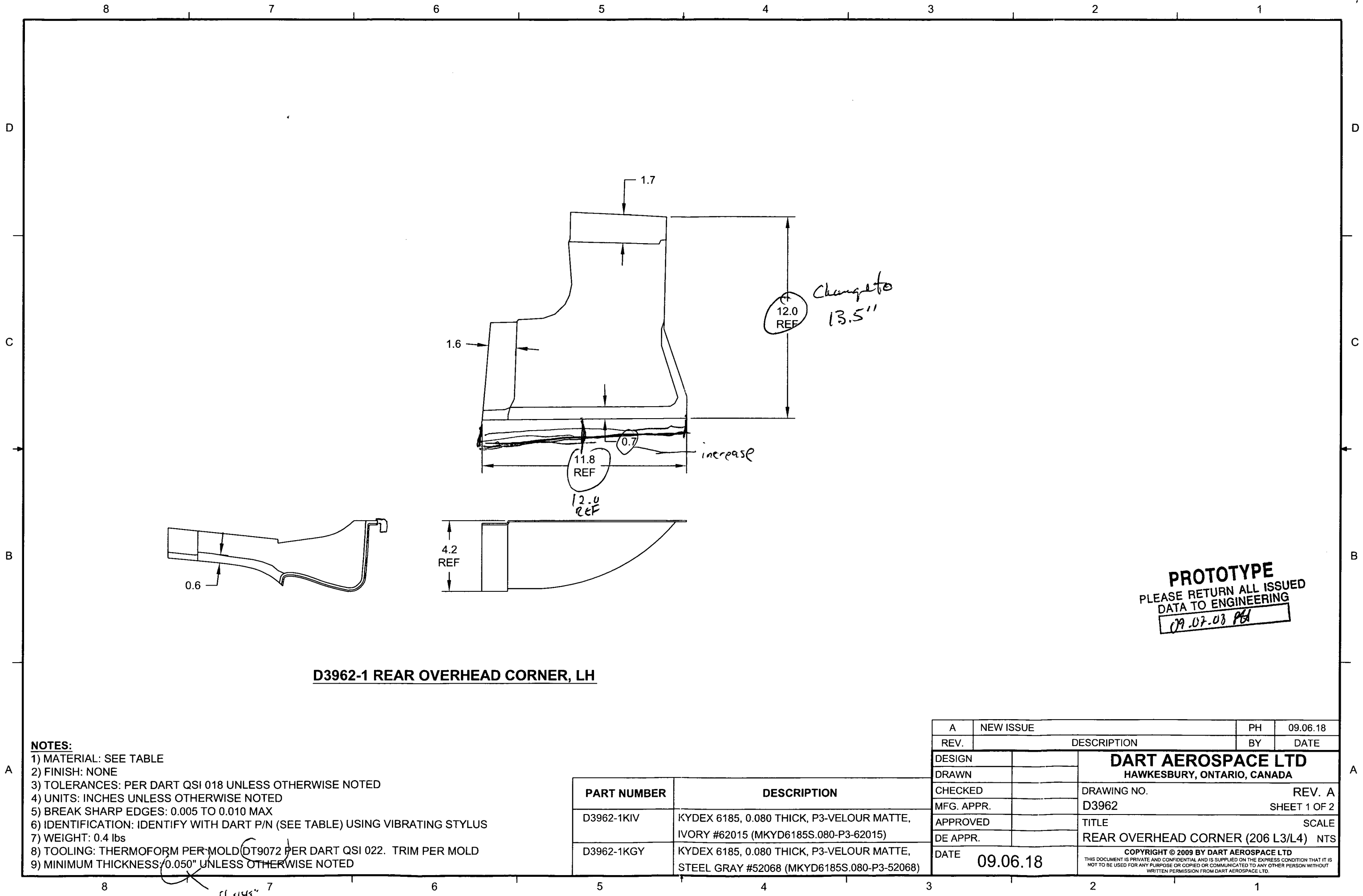
Measured by: BB	Date: 09/07/16
-----------------	----------------

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.7	±.10	1.75"	✓		TAPE	
1.6	±.10	1.625"	✓		TAPE	
11.8	Ref	12.0"	✓		TAPE	
1.6	±.10	.6	✓		Wash	
0.050"	±.005"	0.055"	✓		Wash	
13.5"	Ref.	13.5	✓		TAPE	
0.035	MIN	0.040	✓			

Measured by: D. Leger	Date: 09/07/14
Audited by: BB	Date: 09.07.17
Prototype Approval: BB	Date: 09.07.17

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



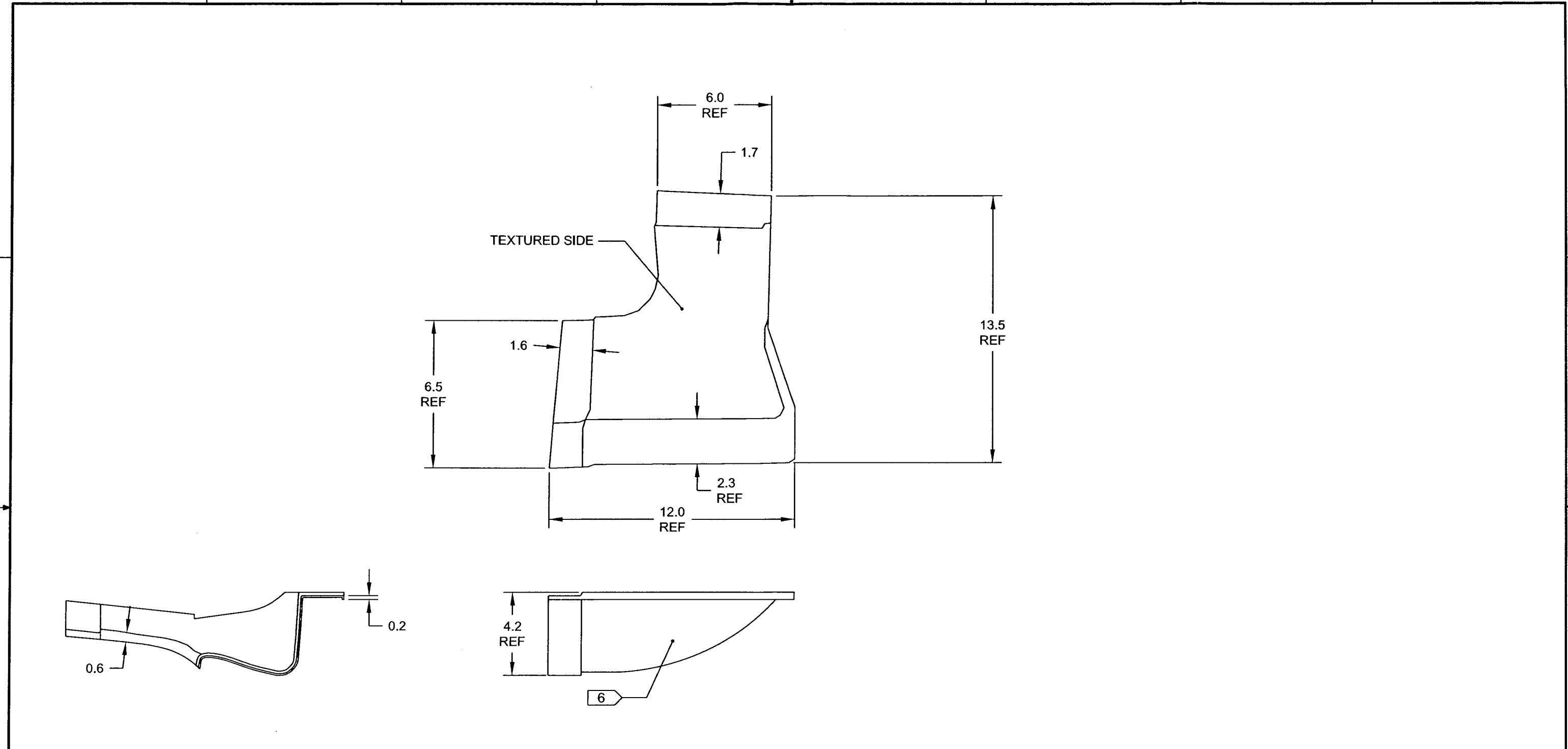
PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
09.07.08 PMA

D3962-1 REAR OVERHEAD CORNER, LH

- NOTES:**
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
 - 7) WEIGHT: 0.4 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD
 - 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3962-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3962-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

A	NEW ISSUE	PH	09.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3962	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		REAR OVERHEAD CORNER (206 L3/L4)	NTS
DATE	09.06.18	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3962-1 REAR OVERHEAD CORNER, LH

- NOTES:**
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
 - 7) WEIGHT: 0.45 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9341 PER DART QSI 022. TRIM PER MOLD
 - 9) MINIMUM THICKNESS: 0.035" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3962-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3962-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

A	NEW ISSUE	PH	09.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3962	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	REAR OVERHEAD CORNER (206 L3/L4)	NTS
DATE	09.06.18	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	